

Work Order ID 56566

Monday, March 01, 2010 2:43:44 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 3/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*Date: *10-3-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

110

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

[Signature] *10-3-3*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC:

Date:

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Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



Skidtubes

Skidtubes

Memo

0.00

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10-3-3

fu

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Stop



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Work Center ID

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004.

A/R□□□ Aluminum Rod

M113207

BE 10/03/04

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M113207

BE 10/03/04

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64".
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 10/03/04

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Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/04

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/04

(X)

7

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

8/10/04

(X)

8

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

0.00

0.00

=> JW 10/03/09

(X1)

φ

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00pm

320°F

1:30pm

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10 3 10

φ

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of SikaFlex on insert holes before installing wearplates
A/R ☐ ☐ ☐ SikaFlex-291 ☐ 112345
SikaFlex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with SikaFlex. Clean excess adhesive
A/R ☐ ☐ ☐ SikaFlex-291 ☐ 112345
SikaFlex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M113462

15/10-3-10. ①

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Stop

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NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

E. W. L. M.

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

(P)

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

*PAP**56124 P-10/3/11*

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/03/16 HJ**ME 10-3-11*

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1



205 Skidtube bent detail

Manufactured No 110 Each 4.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

1356121

4

①

10-3-3

54541

2

56123

2

Manufactured No

140

Each

132.0000

1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

132

46661

85

52215

47

10-03-04

D2576-3



Step (maching detail)

W/O:		WORK ORDER CHANGES					
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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2579

Manufactured

No

140

Each

216.0000

20.0000



Crossbolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

94

51525

4

53780

3

54543

18

56145

69

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

20

BE 10/03/04

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 149.0000 1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST026	149	
50513	1	
50770	1	
51539	37	
53791 ✓	110	

AN3-5A Purchased No 200 Each 1,431.000 2.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1431	
100188	188	
105057 ✓	1243	

1 BR 10-3-11

2. BR 10-3-11.

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L



Washer

Purchased No 200 Each 3,197.000 2,0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3197	
101291	16	
105793	49	
110985 ✓	3132	

ALS7-1032-130



Insert

Purchased No 200 Each 986.0000 50.0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	986	
108606	52	
111529	130	
111779	34	
112772	11	
113238	759	

ALS4-1032-130

2 Bl 10-3-11

50. Bl 10-03-11

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

1,033.000 50.0000



BOLT



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 114103

1033

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113644

394

113749

200

AN960C10L

Purchased

No

200

Each

388.0000 50.0000



washer



Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG 113691

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

WAS149C0332R

50 BL 10-3-11

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No 200 Each 79.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	77	
53461 ✓	77	
Main Warehouse		
ST	2	
45717	1	
50265	1	

1 BR 10-3-11

D3566-5 Manufactured No 200 Each 31.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	27	
55026 ✓	15	
55335	12	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

1 BR 10-3-11

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Start Qty: 1.00

Required Qty: 1.00

D3566-1



Gasket

Manufactured No 200 Each 33.0000 2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP	56532	28
52512		3
54480		1
55011		1
55320		23

Main Warehouse

ST		5
46349		1
51218		1
51259		3

2. BK 10-3-11

D3564-11



Wearshoe

Manufactured No 200 Each 16.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19		14
52125		2
55332	✓	12

Main Warehouse

ST		2
45823		1
50112		1

1 BK 10-3-11

Monday, March 01, 2010 2:43:43 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 56566

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No 200 Each 19.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP17 56285	7	
51611	7	
Main Warehouse		
ST	12	
45409	2	
46495	10	

1 BR 10-3-11

D3564-9 Manufactured No 200 Each 25.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP19	23	
55025 ✓	11	
55334	12	
Main Warehouse		
ST	2	
44659	1	
45825	1	

1 BR 10-3-11

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 56566

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

41.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	37	
51925	1	
54772 ✓	11	
55024	12	
55333	13	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 BR 10-3-11.

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 56566



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

628.0000

16.0000



O-Ring, 205 Skidtube



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

527

51613

27

55546 ✓

500

Main Warehouse

ST

101

52562

101

16. PR 10-3-11.

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 56566



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1 Manufactured No 200 Each 689.0000 16.0000



Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	561	
54008	1	
54643	15	
55002 ✓	545	
Main Warehouse		
ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	

16 BR 10-3-11.

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

36566

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

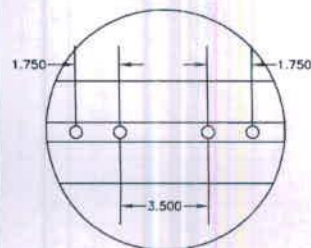
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

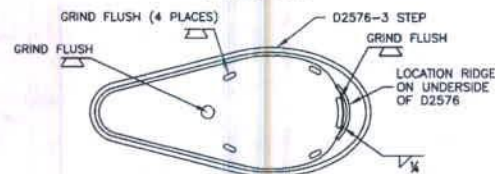
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

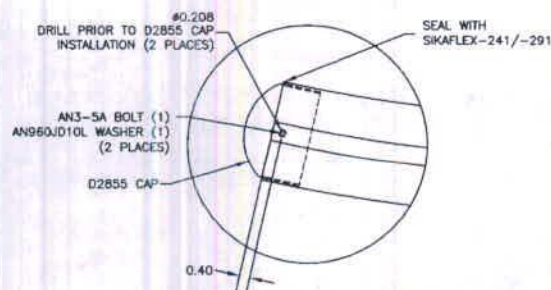


RELEASED
07-06-88

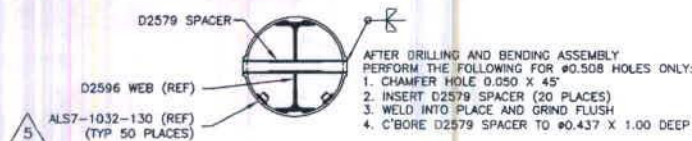
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



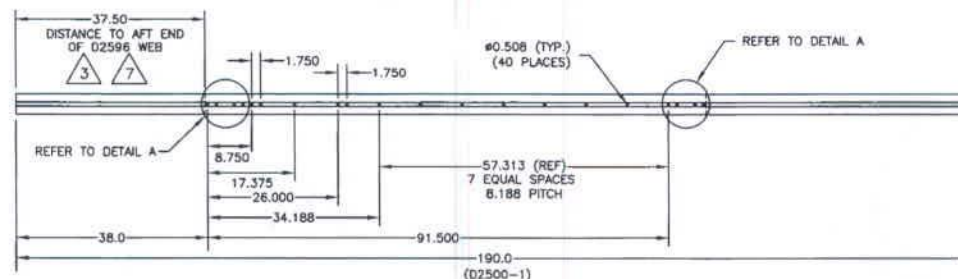
SECTION D-D
SCALE 5:24



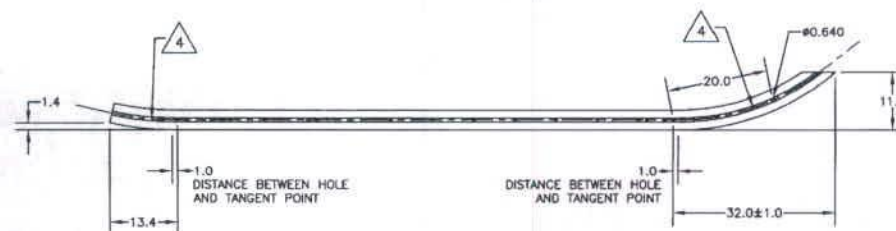
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

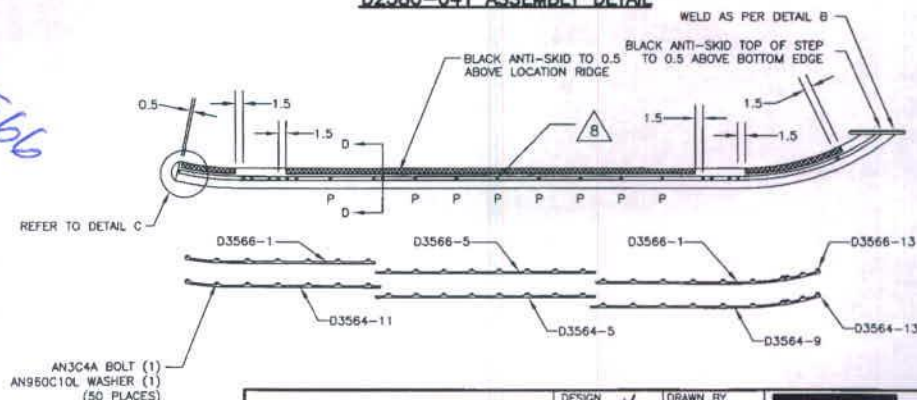
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

A circular cross-section of a pipe is shown. The diameter is labeled as 3.500 inches. The wall thickness is labeled as 1.750 inches on both the left and right sides. The interior of the pipe is divided into three horizontal sections by two horizontal lines. The top and bottom sections are shaded light blue, while the middle section is white. Four small circles are located on the horizontal lines, one in each of the three sections. Arrows point from the labels to the corresponding dimensions.

RELEASED
07-25-2014

Diagram illustrating the underside of the D2576-3 step, showing the location of the grinding ridge and the grinding flush areas. The diagram includes labels for the grinding locations and the grinding ridge.

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- D2576-3 STEP

0.208

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

AN3-SA BOLT (1)

AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

SEAL WITH SIKAFLEX-241/-291

SEE NOTE 1)

0.40

D2579 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.50B HOLES ONLY:

1. CHAMFER HOLE .0050 X .45"
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO .0437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2506 WEB
3
7
REFER TO DETAIL A
1.750
1.750
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
91.500
190.0
(D2500-1)
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL E

(MAKE FROM D2580-1 DRILLING DETAIL)

51.340

39.580

5.915

5.338 (REF)

Ø0.508 (8 PLACES)

Ø0.640

20.0

1.0

32.0 ± 1.0

13.4

DISTANCE BETWEEN HOLE AND TANGENT POINT

4

D2580-045 ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

REFER TO DETAIL G

0.5

1.5

H

NO C'BORE NO PLUG

P P P P P P P P

B

1.5

1.5

1.5

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-1

AN3C4A BOLT (1)

AN980C10L WASHER (1)
(50 PLACES)

DESIGN <i>R/L</i>	DRAWN BY <i>RH</i>	DART
----------------------	-----------------------	-------------

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3,5,8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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DESIGN	RH	DRAWN BY	RH
CHECKED		APPROVED	
DATE			
07.02.27			

DRAWING NO.
02580

TITLE	205 SKIDTUBE ASSEMBLY
-------	-----------------------

REV. D
SHEET 3 OF 3
SCALE
1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56134
Part number: D205 634.041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.02.23

Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

